

Date: Tuesday, 1/31/2006 11:04:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WHEEL SHAFT
 Job Number : 25685
 Estimate Number : 10449
 P.O. Number : *N/A*
 This Issue : 1/31/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 1/31/2006 Type : MACHINED PARTS
 Previous Run : 23022
 Part Number : D33341
 Drawing Number : D3334 REV. B1
 Project Number : N/A
 Drawing Revision : B1
 Material : *N/A*
 Due Date : 2/20/2006 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : *06.01.31*
 Comment : Est: B 05.03.02 Revised material; Added Powder Coat KJ/J
 LM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140HR3500	4140 Heat Treated Bar
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Comment: Qty.: 0.6563 f(s)/Unit Total : 3.9378 f(s)

4140 HEAT TREATED BAR

Material: AISI 4140 or ASTM A304-02/A-434-BC/A193-03-Grade-B7/A29-03/A322-91 or UNS# G41400

(M4140H-R3.500)

Batch: *M10011 46.5"**MS 06/08/29 6*

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI

1- Cut blanks: Ø3.500" Bar to 7.750" long

2- Turn as per Folio FA492 and Dwg D3334

3- Deburr

MS 06/08/30 6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/08/30 6

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS1

Machine as per Folio FA492 and Dwg D3334

Identify as D3334-1

06/09/18 6
J.F. 06/09/15 6

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/09/15 6
06/09/18 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/09/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/15	2.0	While turning the ØD. 3.470 the shaft turned in the chuck, and the tool chattered around the O.D.	J.F. 06/09/15	machine down chatter UNTIL the marks are gone. O.D. is .082" under Nominal .072" under tolerance. Part Acceptable	J.F. 06/09/15	2 06-09-15	J.F. 06/09/15	J.F. 06/09/15

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL SHAFT

Job Number: 25685

Part Number: D33341

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06/09/18 x6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Mask thread and bearing surface

06-08-18

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06 09 18

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W521

562 06/09/18

(3)

EPL 06-09-19

(3)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/19

(3)

Job Completion



U 06-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

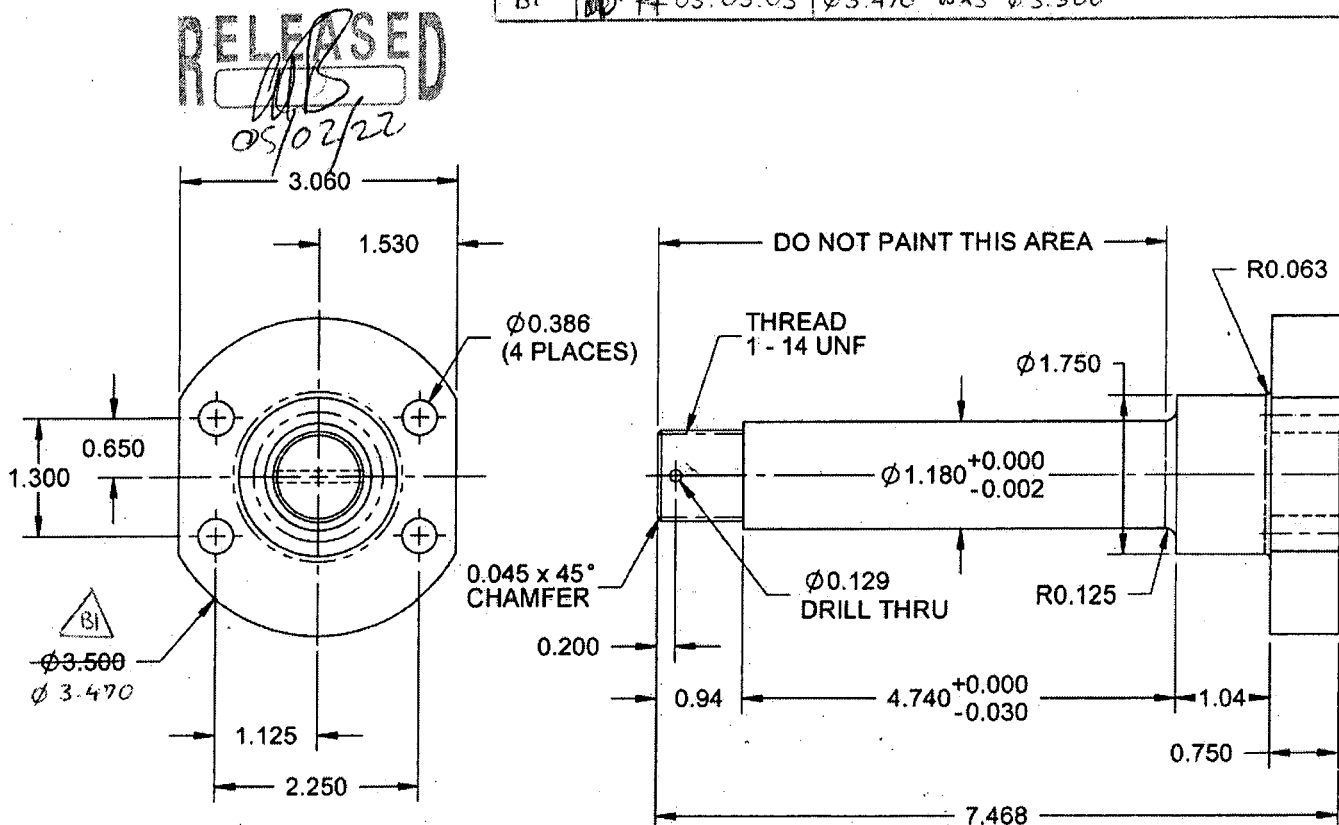
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3334	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE WHEEL SHAFT	SCALE 1:2
A	04.12.16	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASSY	
BI	05.03.03	$\phi 3.470$ WAS $\phi 3.500$	

**D3334-1 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 (REF. DART SPEC. M4140H-R3.500)
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **25685**

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